

Work Order ID 52865

October 16, 2009 8:57:53 AM



Page 1

Item ID: D212-725-1-933

Accept



Setup Start



Revision ID: D

Stop



Item Name: Tube Assembly

Start Date: 10/16/09 Start Qty: 6.00



Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 09/10/16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D212-725-1	D
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0.00

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 10587

Ship to Cintube: QTY P# DESCRIPTION

- (1) AN818-4D NUT

- (1) MS20819-4D SLEEVE

- (4.5 ft) MS052-0TR0.250W0.035 (length may vary)

Fabricate as per dwg D212-725-1

Purchase Part Number: D212-725-1-933

Supplier: Cintube

Certificate of conformity is required

CL 09/10/16 (6)

clean up m.f 09/11/23 (6X)

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Item ID: D212-725-1-933

Accept



Setup Start



Revision ID: D

Stop



Item Name: Tube Assembly

Start Date: 10/16/09 Start Qty: 6.00



Cust Item ID:

Required Date: 12/04/09 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 BR 09-11-23 0.00				6			
150 Packaging Packaging	Identify as per dwg & Stock Location: 386 Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Pc 9/11/23 6

11.09.11.23

ME 09-11-23

Picklist Print.

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Page 1

Work Order ID: 52865

Parent Item: D212-725-1-933

Parent Item Name: Tube Assembly



Comments:

Start Date: 10/16/09


Required Date: 12/04/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052- OTR0.250W.035		Purchased	No			100	f	0.0000	27.0000			
												
5052-O Round Tubing .250" x .035 Wall												
AN818-4D		Purchased	No			100	Each	8.0000	6.0000			
												
Nut												

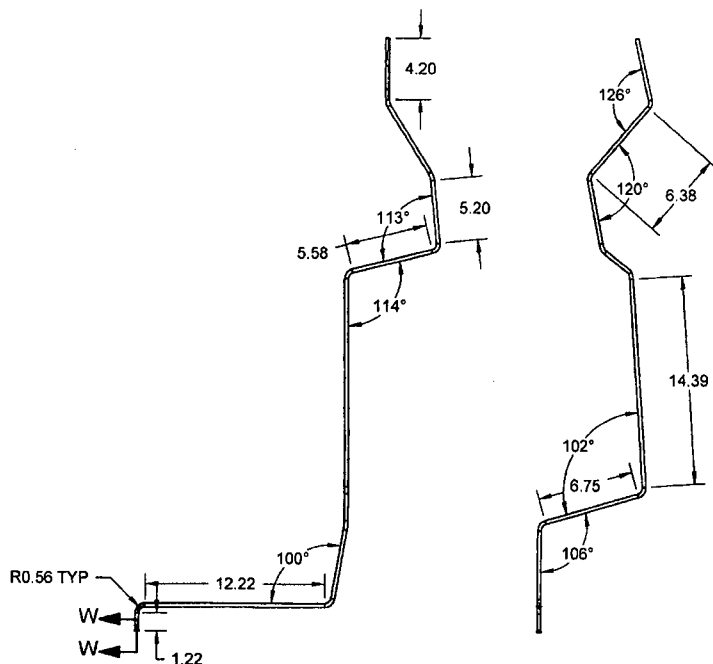
CKC9/10/29 (36ft)
113038

<u>Warehouse</u> <u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse			
ST		8	
1317		8	
MS20819-4D	Purchased	No	
		100	Each
		8.0000	6.0000

6 C209110116

<u>Warehouse</u> <u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse			
ST		8	
1319		8	
Sleeve			

6 C209110116

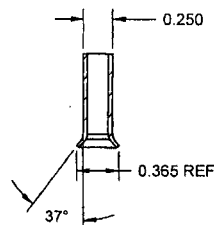


D212-725-1-199 TUBING
(MANUFACTURE PER TEMPLATE DT8915)

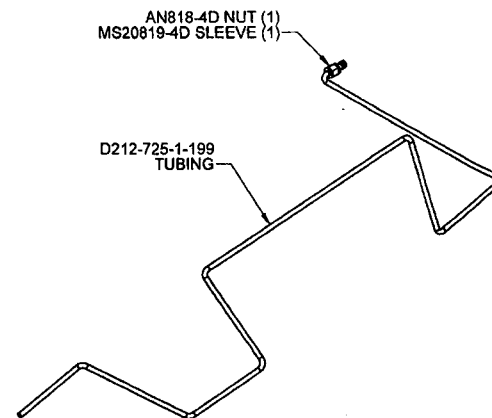
NOTES:

- 1) MATERIAL: 5052-0 ALUMINUM TUBING 0.250 x 0.035 WALL PER (REF. AMS-WW-T-700/4)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1204 PER MIL-C-5541
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D212-725-1-933 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52865
C209110/16



SECTION W-W
SCALE 1:1
(FINISH FLARE THIS
END AFTER ASSEMBLY)



D212-725-1-933 TUBE ASSEMBLY

RELEASED
(08070314)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	N/A	D212-725-1	SHEET 67 OF 67
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	212s DETAIL PARTS	1:12
DATE	08.03.14	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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CLIENT:
DART AEROSPACE LTD.
1270 ABERDEEN ST.

HAWKS BURY
ON K6A 1K7

EXPED. A/TO :
SAME

CINTUBE LTEE/LTD

☒ 333 BOUL. ST-JOSEPH, BUILDING # 105
LACHINE, QUEBEC
H8S 2K9
TEL: (514) 634-3592
FAX: (514) 636-3336 / 8625

☐ 1250 MATHESON BLVD. EAST
MISSISSAUGA, ONTARIO
L4W 1R2
TEL: (905) 625-190
FAX: (905) 625-1500

Rep: PATRICK ZALATAN

BON. LIVR.: RELACHE
PACK. SLIP M-105904
ORDER #: 10587

DATE: 20-Oct-09
COMMANDE #:
ORDER #:

CLIENT NO.	MAT'L PAR / MAT'L BY	REFERENCE	MODE DE PAIEMENT / TERMS OF PAYMENT
MDAR72	CLIENT		C.O.D. (VISA : VOIR CLAIRE)
TRANSPORT		DATE LIV. / DELIV. DATE	CONTACT
PUROLATOR COLLECT #7684382		7 A/TO 10 JOURS/DAYS	LINDA LACELLE

CONTACT PHONE #: (613) 632-9577 EXT. #:
FAX #: (613) 632-1053

QUANT	EXP.	DIMENSION / SIZE	EP / WALL	DESCRIP. MAT'L. / MAT'L DESCRIP.	DEG.	RAY. / RAD.	TANGENTE / TANGENT	INSTRUCTIONS
6	6	0.25 OD	0.035	PART NO. DART D212-725-1-933P TUBE ALUMINIUM	MULTIPLE BENDS	0.56 CLR	SEE DRWG: D212-725-1-933P	FINAL CUT & FLARE
6	6	0.375 OD	0.035	PART NO. DART D212-725-1-917P TUBE SS/304/316L	MULTIPLE BENDS	0.94 CLR	SEE DRWG: D212-725-1-917P	FINAL CUT & FLARE
6	6	0.75 OD	0.049	PART NO. DART D212-725-1-921P TUBE SS/304/316L	2 BENDS	1.75 CLR	SEE DRWG: D212-725-1-921P	FINAL CUT & FLARE
3	1			LETTRE OF COMPLIANCE				

Notes:

CATEGORIE ISO
ISO CATEGORY

1	2	3
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

ASME ☐

LETTRE DE CONFORMITE
LETTER OF COMPLIANCE

OUI
YES ☒

DATE CLIENT AVIS. / ADV.:

CONTACT:

PAR/BY:

EXPEDIE PAR / SHIPPED BY:

DATE:

CLIENT:

DATE:

Dart Aerospace
1270 Aberdeen St
Hawkesbury ont
K6A-1K7

N° DE COMMANDE - ORDER NO.	DÉP. - DEPT.	DATE
VENDU À - SOLD TO	EXPÉDIÉ À - SHIP TO	
ADRESSE - ADDRESS	ADRESSE - ADDRESS	

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
	P10: 10587		Patrick attn: Zolatan	514-634-3592

36 f - m5052-OTR0.250W.035 m113038

to use on D212-725-1-933 REV. D
B 52865.

thanks
Chantal

			TPS/GST		
			TVP/PST		
513851	SIGNATURE	N° LIC. - LIC. NO.	TOTAL		

Dart Aerospace
1270 Aberdeen St.
Hawkesbury ont.
K6A-1K7

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.		DATE	
				09/10/16	
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO			
		Cintube 333 St-Joseph Blvd			
ADRESSE - ADDRESS		ADRESSE - ADDRESS			
		Machine QC H8S-2K9			
DATE D'EXPÉDITION - SHIPPING DATE		VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
7/10/10587			attn: Patrick	2610101	514-634-3592
6	D212-725-1-917 B 52866				
	material: m304TR0.375xW035 m110113 6.6 ft				
	nest will ship on oct. 23?				
	nut: A10818-6J m102850 x12				
	sleeve: mS20819-6J m102850 x12				
6	D212-725-1-933 B 52865				
	material: m5052-OTR0.250"X035W will				
	ship on oct 23?				
	nut: A10818-4D m1317 x6				
	sleeve: mS20819-4D m1319 x6				
6	D212-725-1-921 B 52716				
	material: m304TR 0.750 x .049 wall m112800				
	nut: A10818-12J m1238x11/m109740 x1				
	sleeve: mS20819-12J m1251 x10 / m819 x2				
	Manufactured as per drawing D212-725-1-917 REV. B				
	933 REV. D				
	Please ship per attached: 921 REV. B				
	acct: 7684382				
					TPS/GST
					TVP/PST
513995		SIGNATURE		N° LIC. - LIC. NO.	TOTAL